

Dep May 14

TRIMMED

Work Order ID 84248

84248

Page 1

May-08-12 12:57:59 PM

Item ID: D4640-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Aft Wall Protector

Stop *NS2*

Start Date: 08/05/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12/05/08 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4640

A

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg

Prog Rev: A

Dwg Rev: A

Deburr as required

0.00

1 0 JM / SA
12-5-9

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

1 0 JM / SA
12-5-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84248

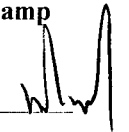
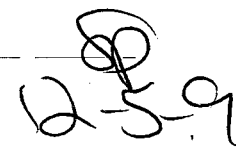
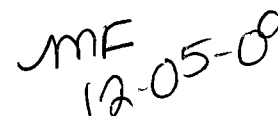
May-08-12 12:57:59 PM

84248

Page 2

Item ID: D4640-7 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Wall Protector
 Start Date: 08/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 22/05/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				①			 12-05-09
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00				12			 12-5-9
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/05/1009  ME 12-05-09

PP 84248

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-08-12 12:58:03 PM

Page 1

Work Order ID: 84248

84248

Parent Item: D4640-7

D4640-7

Parent Item Name: Aft Wall Protector

Start Date: 08/05/2012

Required Date: 22/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-02		Purchased	No			100	sf	272.7275	2.385	2.510526			

MI FXS 093-F6006-02

**

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

therm

272.7274879

106751

97.9159079

110877

174.81158

110877

52/
12-5-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

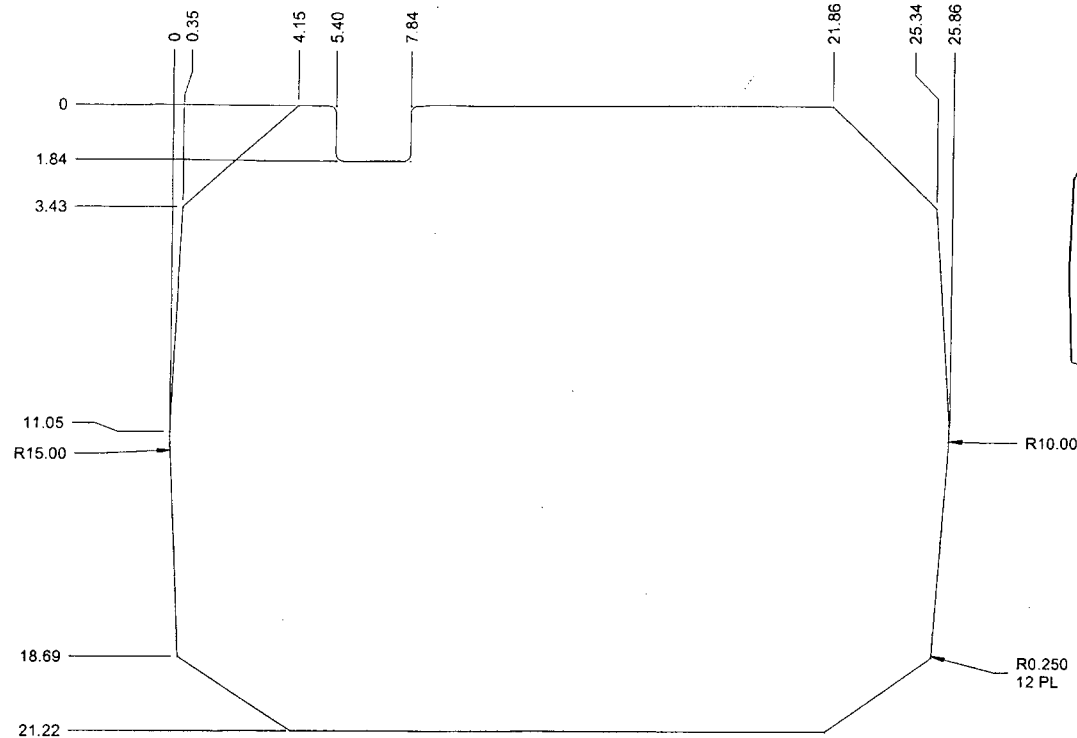
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

0.093
REF



D4640-3 FORWARD WALL PROTECTOR
TEXTURED SIDE SHOWN

84248

RELEASED
2012-05-07
JW

NOTES:

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 2.07 lbs
- 8) CHECK PER TEMPLATE DT8925

DESIGN	DE	DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

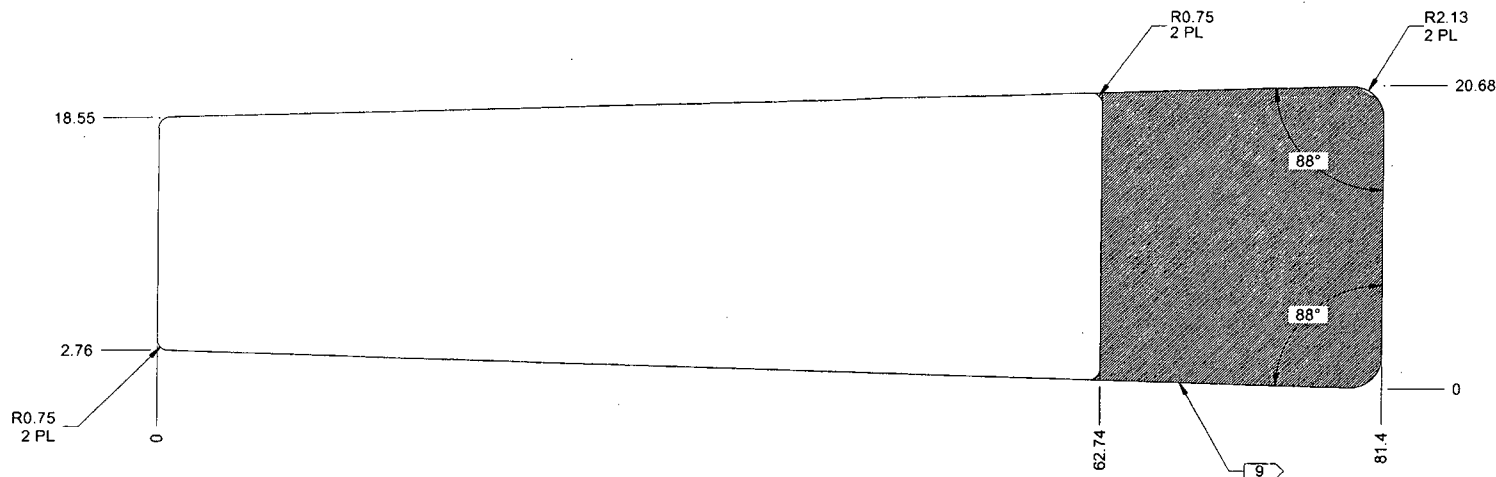
8 7 6 5 4 3 2 1

D

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A



D4640-5 LH WALL PROTECTOR
TEXTURED SIDE SHOWN

RELEASED
2012-05-07
NH

NOTES:

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 6.00 lbs (TRIMMED WEIGHT = 4.49 lbs)
- 8) CHECK PER TEMPLATE DT8926
- 9) REMOVE SHADED AREA IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER

DESIGN	JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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8 7 6 5 4 3 2 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

17x20"

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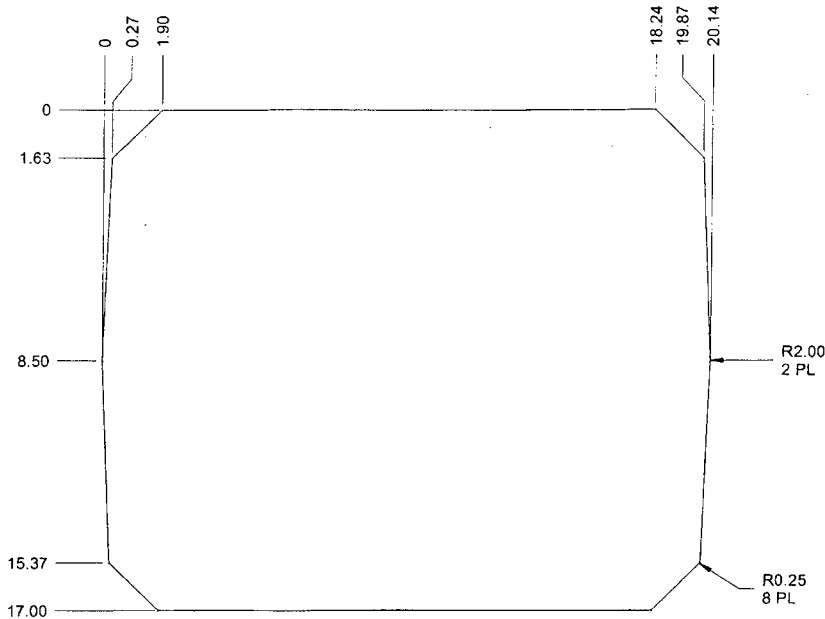
D

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0.093
REF



84248

D4640-7 AFT WALL PROTECTOR
TEXTURED SIDE SHOWN

RELEASED
2012-05-07
MR

NOTES:

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 1.34 lbs
- 8) CHECK PER TEMPLATE DT8927

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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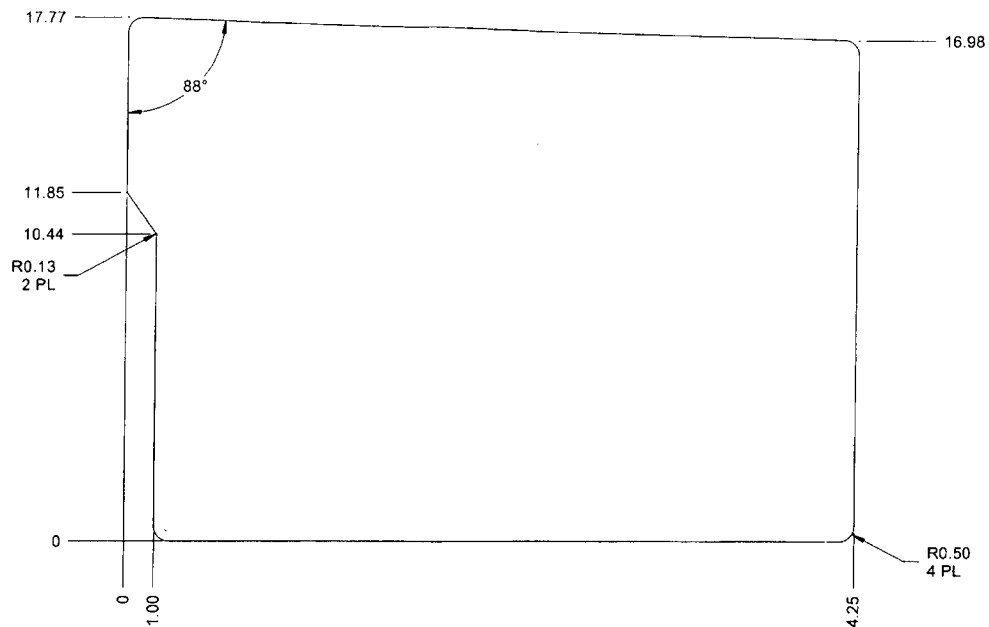
1

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C

B

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0.093
REF

D4640-9 RH AFT WALL PROTECTOR
TEXTURED SIDE SHOWN

84248

RELEASED
2012-05-07
MP

NOTES:

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 1.65 lbs
- 8) CHECK PER TEMPLATE DT8928

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8

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Dart Aerospace Ltd

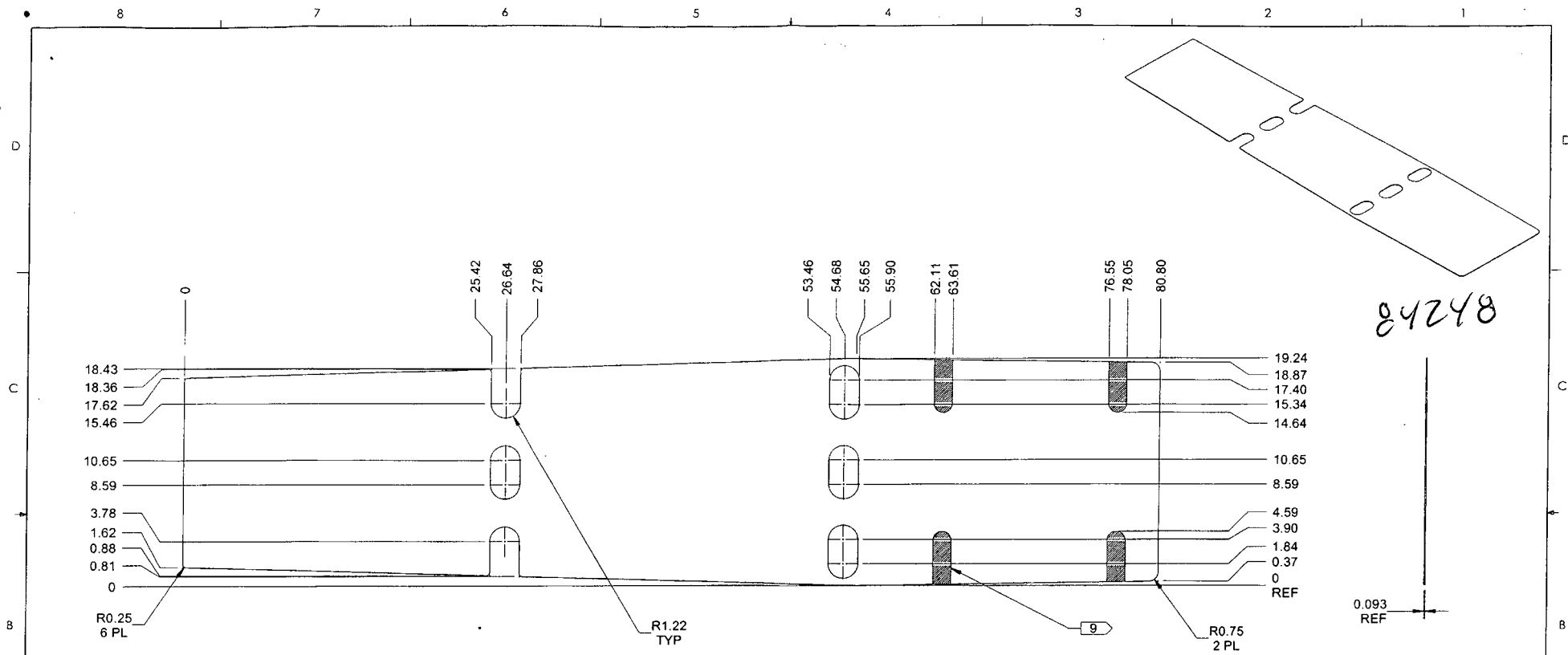
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



84248

D4640-11 FLOOR PROTECTOR
TEXTURED SIDE SHOWN

RELEASED
2012-05-07
JW

- NOTES:
- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-02
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
 - 7) WEIGHT: 5.66 lbs (TRIMMED WEIGHT = 5.56 lbs)
 - 8) CHECK PER TEMPLATE DT8929
 - 9) REMOVE SHADED AREA IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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A

A

0.093
REF

16.75

9.59

R0.50
4 PL

6.84

0.67

0

1.50

D4640-13 DOOR PROTECTOR
TEXTURED SIDE SHOWN

89°

89°

17.43

R3.50
4 PL

0

27.25

84248

RELEASED
2012-05-07
M**NOTES:**

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 1.78 lbs
- 8) CHECK PER TEMPLATE DT8930

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

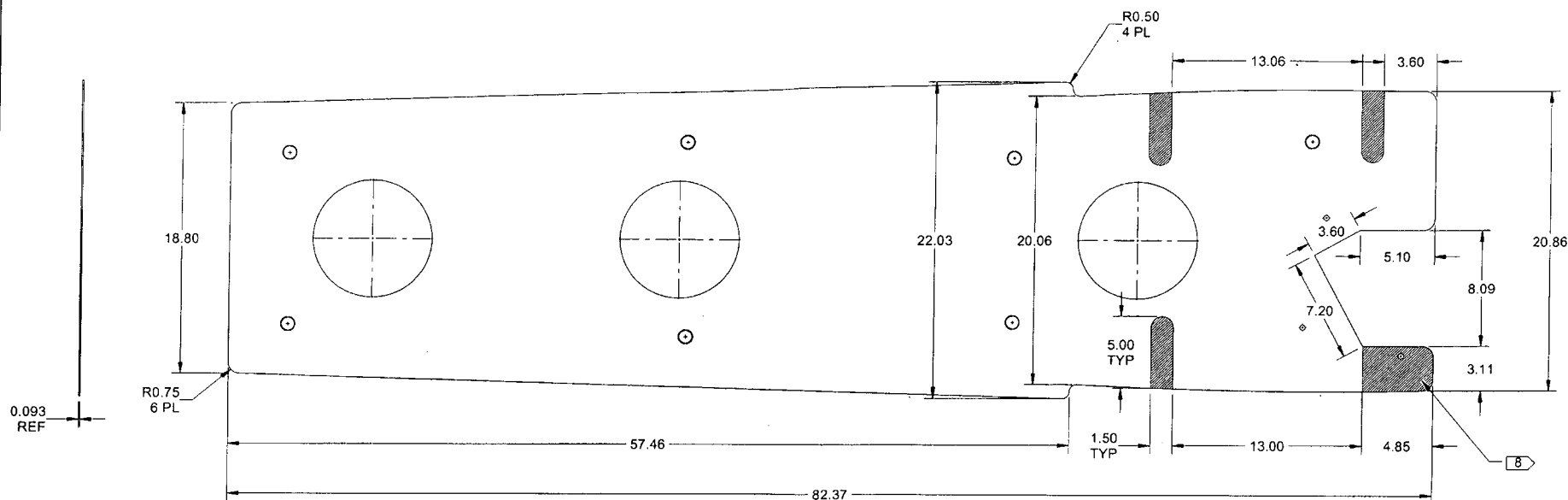
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

84248



D4640-15 CEILING PROTECTOR
TEXTURED SIDE SHOWN

RELEASED
2012-05-07

NOTES:

- 1) MATERIAL: F6006-701 BLACK LEXAN SHEET (SUEDE/POLISHED TEXTURE) 0.093 THICK
REF DART SPEC MLEXS.093-F6006-02
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 ON SMOOTH SIDE
- 7) WEIGHT: 5.84 lbs (TRIMMED WEIGHT = 5.84 lbs)
- 8) REMOVE SHADED AREA IF CUSTOMER REQUESTS "TRIMMED KIT" ON PURCHASE ORDER

DESIGN	XDF	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BE	DRAWING NO.	REV. A
MFG. APPR.	BE	D4640	SHEET 8 OF 9
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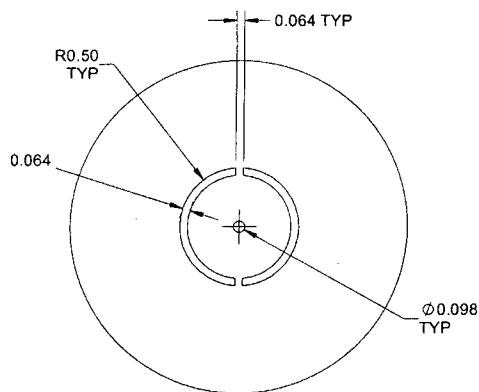
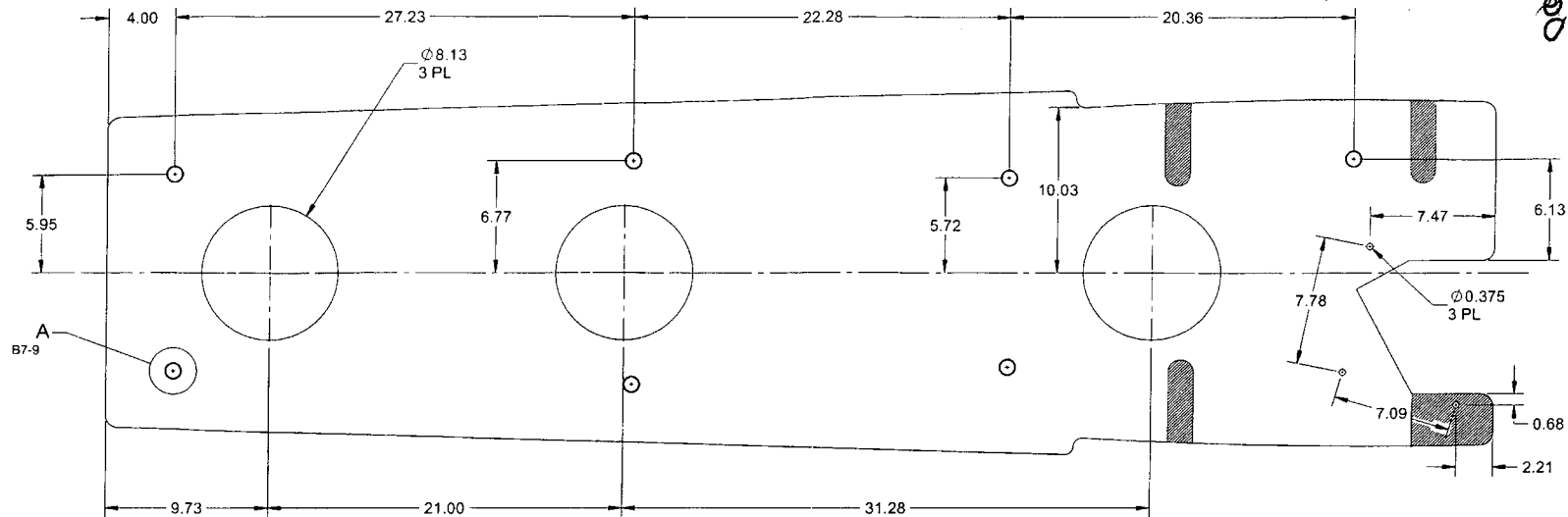
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4640-15 CEILING PROTECTOR
SUPPLEMENTAL VIEW

RELEASED
2012-05-07
ND

DESIGN	XDF	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BE	DRAWING NO.	REV. A
MFG. APPR.	BE	D4640	SHEET 9 OF 9
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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